



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.3917

Job Sheet 212208



Part No: 647.3917

Job Qty: 8 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/20

Job Tracking No:

Due Date: 8/31/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C2 SHEETS 1,12 IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	3 pcs	8/24/20	8/24/20	0.17	0.30	Waterjet - Flow		20/08/25
120	QC 2	3 pcs	8/24/20	8/24/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/08/25
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S295956



Part: 647.3917

Job No: 212208

Serial No/Batch: S295956

Revision: Rev C2

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/02/20

130	QC 8	3 pcs	8/24/20	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Outsource - 4 - Anodize	3 pcs	8/31/20		ATG001-VC	5
150	Packaging 2-1 - Receive - B4B	3 pcs	8/31/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	

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				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
160	QC 5	3 pcs	8/31/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
					QC 5 - 82
190	Packaging 3-1 - Stock - B4B	3 pcs	8/31/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B

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					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	SEP 04 2020 DAS 70
					QC 21 - SA - 9	
					QC 21 - SA - 77	9-89

Part Op 110 - 1-Cut as per Dwg Dwg Rev: 12 Prog Rev: 12 2-Deburr if necessary
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - Issue P/O to ATG : 469160, HARD ANODIZE, COLOR BLACK, AND PRIME AS PER DWG 647.3900 REV. C
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC5- Inspect part completeness to step on W/O)
 190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.090	2024-T3 .090 Sheet	.1302 sf (.0434 ea)	110-Waterjet - Flow - 1	FM130387-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.090	0	156	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.196inches + 0.005 - 0.001	0.201 0.195	0.197 diameter	
2	Doubler	0.625inches ± 0.010	0.635 0.615	0.630	
3	Doubler	0.500inches ± 0.010	0.510 0.490	0.503	
4	Doubler	2.000inches ± 0.010	2.010 1.990	2.003	
5	Doubler	3.500inches ± 0.010	3.510 3.490	3.502	
6	Doubler	6.500inches ± 0.010	6.510 6.490	6.501	
7	Doubler	8.000inches ± 0.010	8.010 7.990	8.002	
8	Doubler	9.500inches ± 0.010	9.510 9.490	9.501	
9	Doubler	10.000inches ± 0.010	10.010 9.990	9.999	
10	Doubler	0.090inches ± 0.010	0.100 0.080	0.091	

Plex 8/13/20 11:01 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S295956



Part: 647.3917

Job No: 212208

Serial No/Batch: S295956

Revision: Rev C2

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/26/20



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046960



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046960

PO Date: 8/26/20

Due Date: 9/11/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-09-01

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212436	649.4814	649.4800 Rev E	Doubler : Various STC's ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P- 23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed X10	-	9/4/20	10 pcs	0 pcs	10 pcs	\$7.52/pcs	\$75.20
2	210880-A	646.9715	646.9700 Rev.J	Body : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X1	-	9/11/20	1 pcs	0 pcs	1 pcs	\$15.77/pcs	\$15.77
3	211112	RB H4713-1	RB H4713 Rev F	Drain Hose Body -Issue P/O to ATG - STRIP -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RB910-0020-1 Rev. 2	Firmed X4	-	9/11/20	4 pcs	0 pcs	4 pcs	\$8.41/pcs	\$33.64



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PURCHASE ORDER

POHB046960



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	R209885	RBW6210G01631-8G-4	RBW6210G01631-8G Rev C	Support -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X1	-	9/11/20	1 pcs	0 pcs	1 pcs	\$8.41/pcs	\$8.41
								SEP 02 2020				
5	211997	C2-1-1	C2-1-1 Rev 4	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed X6	-	9/4/20	6 pcs	0 pcs	6 pcs	\$8.41/pcs	\$50.46
								SEP 02 2020				
6	209034	649.5113	649.5100 Rev D	Wiper Deflector Shim : Various STC's - Issue P/O to ATG : - Hard Anodize Black, Type 3, Class 2 as per Dwg. - Prime as per Dwg. Certification of Conformity is required.	Firmed X16	-	9/4/20	16 pcs	0 pcs	16 pcs	\$7.52/pcs	\$120.32
								SEP 02 2020				
7	209032	649.5110	649.5100 Rev D	Wiper Deflector : Various STC's Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 649.5100 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed X16	-	9/4/20	16 pcs	0 pcs	16 pcs	\$9.82/pcs	\$157.12
								SEP 02 2020				
8	212208	647.3917	647.3900 Rev C2	Doubler : Various STC's Issue P/O to ATG : HARD ANODIZE, COLOR BLACK, AND PRIME AS PER DWG 647.3900 REV. C	Firmed X14	-	9/4/20	14 pcs	0 pcs	14 pcs	\$7.87/pcs	\$110.18
								SEP 02 2020				

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PURCHASE ORDER
POHB046960



Grand Total: \$821.00

K. Luerin



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB046960



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/1/20 1:23 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920746

Date: 01-Sep-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 10 ea	Part: 649.4814 Rev: E Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28044 Line: 1 PO: POHB046960		
✓ 8 ea	Part: 649.5213 Rev: C Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot # 5265778 Expiry Date: 8/23/21 Job: 28053 Line: 10 PO: POHB046960		
✓ 12 ea	Part: 649.5210 Rev: C Doubler Black Hard Anodize per MIL-A-8625, Type III, Class 2 Primer Paint per MIL-P-23377J, Type 1, Class N Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28054 Line: 11 PO: POHB046960		
✓ 1 ea	Part: 646.9715 Rev: J Body		

RECEIVED
SEP 01 2020
DART AEROSPACE LTD.

1-Box

Made in Canada.

RECEIVED

SEP 01 2020

DART AEROSPACE LTD.

1-Box



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920746

Date: 01-Sep-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28045 Line: 2 PO: POHB046960		
✓ 16 ea	Part: 649.5113 Rev: D Wiper Deflector Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28049 Line: 6 PO: POHB046960		
✓ 16 ea	Part: 649.5110 Rev: D Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28050 Line: 7 PO: POHB046960		
✓ 14 ea	Part: 647.3917 Rev: C2 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Made in Canada.		

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920746

Date: 01-Sep-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 8/23/21 Job: 28051 Line: 8 PO: POHB046960		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>SEP 01 2020</u> Certified Signature:  Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			